

Work Order ID 150198

Wednesday, August 24, 2016 11:50:57 AM

U/R

150198

Page 1

Item ID: D412-705-015

Accept

N900040100

Setup Start

NS1

Revision ID: URF 16-530

Item Name: Drive Shaft Tunnel Modification

Stop

NS2

Start Date: 8/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

DAS

Date: **AUG 25 2016**

Tooling:

Date:

Run Start

NR1

QC:

21

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DAS
6
9-8

OCT 1 2 2016

DAS
21
9-89

16-10-12

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-705-015

CHG 005

DAS
27
9-89

OCT 1 9 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

DAS
28
9-89

OCT 1 2 2016

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

OCT 1 9 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Work Order ID 150198

Wednesday, August 24, 2016 11:50:57 AM

150198

Page 2

Item ID: D412-705-015**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:** URF 16-530**Item Name:** Drive Shaft Tunnel Modification**Stop*****NS2*****Start Date:** 8/18/2016 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 8/24/2016 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

130

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-705-015
Location : FG027DAS
28
9-89
DAS
27
9-89

OCT 19 2016

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.02

DAS
21
9-89

OCT 20 2016

VS 16/10/20

DAS
21
9-89

OCT 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Wednesday, August 24, 2016 11:51:00 AM

Page 1

Work Order ID: 150198

150198

Parent Item: D412-705-015

D412-705-015

Parent Item Name: Drive Shaft Tunnel Modification

Start Date: 8/18/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B Removed Manufacturing 06-10-03 JLM

IPP Rev:C ECN 1052 07-11-05 DD verified by:EC

IPP Rev:D

ECN 12-670 12.11.07 DD Verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C3A		Purchased		No		110	Each	192.0000	22	22			

AN3C3A

Bolt

Location

Loc Qty

Loc Code

GA	66	
m134055	66	
ST350	126	
m135058	10	
m135127	116	

OCT 17 2016

DAS 6 9-89
DAS 28 9-89

DAS
27
9-89

22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Wednesday, August 24, 2016 11:51:01 AM

Work Order ID: 150198

150198

Parent Item: D412-705-015

D412-705-015

Parent Item Name: Drive Shaft Tunnel Modification

Start Date: 8/18/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

110

Each

1,584.000

3

3

AN3C4A

Bolt

OCT 12 2016

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

20

122814

20

FP001

964

M133440

7

M134396

41

M134509

6

M134606

29

M134676

44

M134762

106

M134861

13

M135058

644

M135127

22

M135297

52

OVER002

500

M135127

0

M135297

0

M135442

500

ST350

100

M132317

3

M134134

18

M134396

79

D3256-1

Manufactured

No

110

Each

1.0000

1

1

D3256-1

Panel

OCT 12 2016

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST484

1

142302

1

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

Wednesday, August 24, 2016 11:51:01 AM

Page 3

Work Order ID: 150198

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Parent Item: D412-705-015

D412-705-015

Parent Item Name: Drive Shaft Tunnel Modification

Start Date: 8/18/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

D3256-3 Manufactured No

110 Each 9.0000 1 1

D3256-3

Gasket

**

OCT 12 2016 9-89-89 **DAS 628**

Location

Loc Qty

Loc Code

ST486

9

129868

1

137200

8

MS20427M3-3

Purchased No

110 Each 1,436.000 44 44

MS20427M3-3

Rivet

**

OCT 12 2016 9-89-89 **DAS 28**

Location

Loc Qty

Loc Code

GA

1247

m133577

271

m134738

976

ST311

189

m134738

189

MS21060-L3K

Purchased No

110 Each 121.0000 22 22

MS21060-L3K

Nut Plate

**

135544 x 20

OCT 12 2016 9-89-89 **DAS 28**

Location

Loc Qty

Loc Code

GA

87

m132256

37

m135297

50

ST300

34

m134370

1

m134861

1

m135127

32

DAS 27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																													
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Picklist Print

Wednesday, August 24, 2016 11:51:01 AM

Page 4

Work Order ID: 150198

150198

Parent Item: D412-705-015

D412-705-015

Parent Item Name: Drive Shaft Tunnel Modification

Start Date: 8/18/2016

Required Date: 8/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS9321-09

Purchased

No

110

Each

142.0000

25

25

MS9321-09

Washer

DAS

6

9-89

OCT 12 2016

DAS
27
9-89

Location

Loc Qty

Loc Code

ST267

142

m134676

92

m135470

50

25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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REFERENCE ONLY

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1 ✓					D3256-1	ACCESS PANEL
		1 ✓					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22 ✓	30		6		AN3C3A	BOLT
		3 ✓					AN3C4A	BOLT
						30	AN960JD10	WASHER
16		44 ✓	36		12		MS20427M3-3	* RIVET
						4	MS21051-L3K	NUT PLATE
8		22 ✓	18		6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
		25 ✓	30		6		MS9321-09	WASHER

* Acceptable to substitute for MS20615M3-3 rivets. At installation, it is acceptable to use longer rivets if required.